

Date: Thursday, 05/02/2009 3:42:25 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BELL CRANK
Job Number :	45542		
Estimate Number :	11967		
P.O. Number :		Part Number :	D2056
This Issue :	05/02/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2056 REV B2
First Issue :	/ /	Project Number :	N/A
Previous Run :	39434	Drawing Revision :	B2
	Type :	Material :	
	MACHINED PARTS	Due Date :	10/03/2009
Written By :		Qty:	20
Checked & Approved By :	JUD 09.02.06	Um:	Each
Comment :	Est. E 02.04.04 Added Rev.B2 NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25
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Comment: Qty.: 0.2494 f(s)/Unit Total: 4.9875 f(s)
 6061-T6 Bar 1.25 x 1.25"
 Material: 6061-T6, 1.250" x 1.250"

Batch: M110001

J.F. 09/02/09

(20)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks 2.80" long

J.F. 09/02/09

(20)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio D2056
 Tumble
 Deburr any rough edges after tumbling

J.F. 09/02/10

(20)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/02/10

(20)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 09/02/11

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BELL CRANK

Job Number: 45542

Part Number: D2056

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(20X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

09/02/14

7.0

POWDER COATING

POWDER COATING



M105642



(20X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005.4.3

START TIME:

10:10

OVEN TEMPERATURE:

320°F

FINISH TIME:

10:40

M-L

09/02/14

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9/2/17

SP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 10

9/2/17

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/18

Job Completion



MF
09-02-18

DART AEROSPACE LTD		Work Order: W 5542
Description: Bell Crank		Part Number: D2056
Inspection Dwg: D2056	Rev: B2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/-0.010	0.752	✓			
0.900	+/-0.010	0.902	✓			
1.000	+/-0.010	1.002	✓			
0.125	+/-0.010	0.124	✓			
0.060	+/-0.010	0.060	✓			
Ø0.191	+0.005/-0.001	0.194	✓			
0.362	+/-0.010	0.364	✓			
0.750	+/-0.010	0.752	✓			
0.385	+/-0.010	0.385	✓			
Ø0.257	+0.006/-0.001	0.260	✓			
0.100	+/-0.010	0.100	✓			
0.300	+/-0.010	0.300	✓			
0.946	+/-0.010	0.946	✓			
0.750	+/-0.010	0.750	✓			
0.075	+/-0.010	0.075	✓			
2.637	+/-0.010	2.639	✓			
0.375	+/-0.010	0.375	✓			
Ø0.513-0.518	0.513 - 0.518	0.517	✓			
R0.450	+/-0.010	0.450	✓			
R0.125	+/-0.010	0.125	✓			
R0.200	+/-0.010	0.200	✓			
R0.550	+/-0.010	0.550	✓			
R0.263	+/-0.010	0.263	✓			

Measured by: JTP
Date: 09/02/10

Audited by: SN
Date: 05/02/11

Prototype Approval: N/A
Date: N/A

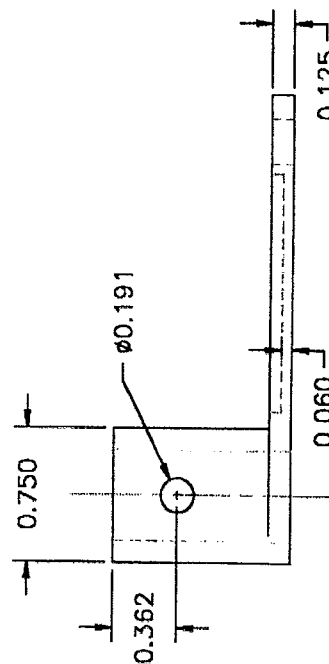
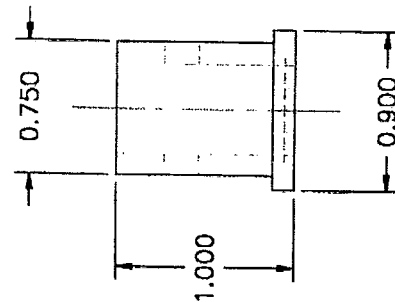
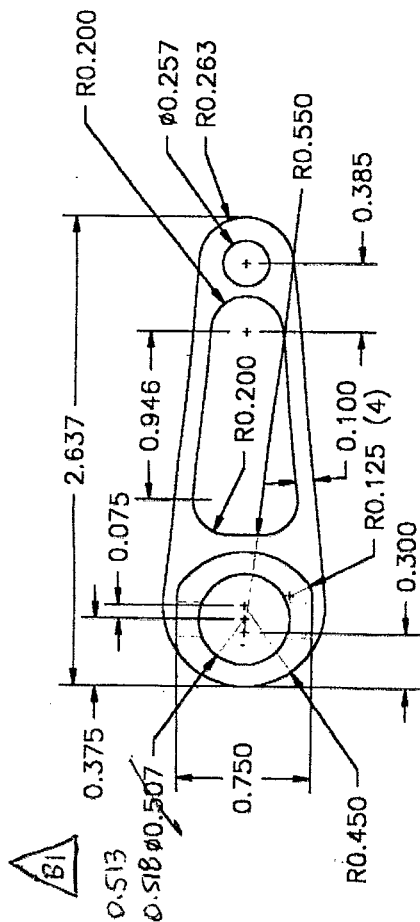
Rev	Date	Change
A	08.04.11	New Issue

Revised by: J/DD	Approved: [Signature]
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RELEASE
99.04.29 LE

DESIGN		DRAWN BY		DART AEROSPACE LTD	
B WILLIAMS		K HAND		VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED		APPROVED		DRAWING NO.	
<i>BW</i>		<i>KE</i>		D2056	
DATE		TITLE		REV. B	
92:03:13		BELL CRANK		SHEET 1 OF 1	
B		95:11:02		SCALE	
				1:1	
B1		01.06.04		RE-DESIGN	
B2		01.12.20		MODIFY HOLE SIZE, ADD P/LC OPTION	
				ADD NOTE ON TOLERANCES	



ACID ETCH OF ALUMINE PER
DINET QSS COS 4.1
POWDER COAT BLACK SINTER
(4.3.5.7) REE DINET
QSS COS 4.3

MATERIAL: 6061-T6 (QQ-A-225/8)
FINISH: ANODIZE (BLACK) OR —

TOLERANCES ARE PER DWT QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45342